Each

Monday, 5/1/2006 4:23:41 PM Kim Johnston User: **Process Sheet Drawing Name** : HEATER TUBE LOCATOR : CU-DAR001 Dart Helicopters Services Customer Job Number : 26916 : 10405 **Estimate Number** : D2408 P.O. Number :NIA **Part Number** S.O. No. : N/A : 5/1/2006 **Drawing Number** D2408 REV. A This Issue : N/A : NC **Project Number** Prsht Rev. : MA : MACHINED PARTS **Drawing Revision** Type First Issue : NIA : 269166 **Previous Run** Material)Due Date : 6/30/2006 Qty: 14 Um: Written By Checked & Approved By Reformat; Incorporated D2292; Comment : Est:C 03.04.14 D2375-3-08-106; D2403 - D2417 KJ/RF **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 5052-H32 .063 Sheet 1.0 M5052H32S063 0.1415 sf(s)/Unit Total: Comment: Qty.: 1.9816 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.063" thick Batch: M19296 (M5052H32S.063) SHEAR 2.0 SHEAR Comment: SHEAR HAAS CNC VERTICAL MACHINING #1 3.0 Water jet Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA158 and Dwg D240 Stack of 7 Identify as D2408 4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

SAD

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8 5.0

SECOND CHECK

Comment: SECOND CHECK

Don Mondon Section

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DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:		\	WORK OR	DER NON-CONFO	DRMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B ption	Sign & Date	Verific Section		Approval Chief Eng	Approval QC inspector
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NOTE: Date & initial all entries

Monday, 5/1/2006 4:23:41 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: HEATER TUBE LOCATOR Customer: CU-DAR001 Dart Helicopters Services Job Number: 26916 Part Number: D2408 Job Number: Machine Or Operation: Seq. #: Description: SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 5743 Location:_ DC DOCUMENT CONTROL 9.0 U 06.06.05 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

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W/O: DATE	STEP	PR	WORK OF	RDER CHA	NGES	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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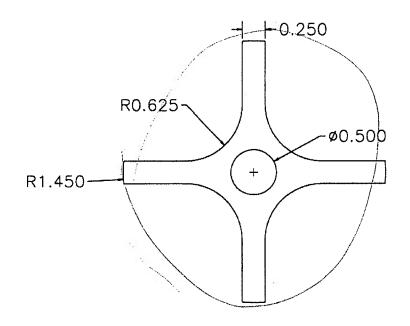
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		STED Description of NC		Corrective Action Section B	Verification						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries



PREPARED B. William	s		CCESSORIES INC
CHECKED	APPROVED	D2408	REV. A
Bate	100	TITLE	SCALE
Apr. 6, 1	995	HEATER TUBE LOCA	ATOR 1:1

RELEASED



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

MATERIAL: 5052-H34 0.063THICK

WORK ORDER NO. 26976

DART AEROSPACE LTD	Work Order: 26916
Description:	Part Number: D2408
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+ 0.010	0.255			Vern	
+ 0.010	RO. 625			Radius GAUGE	
+0.006/-0.001	\$0.500	~		Vern	
	-				
		 			- C.
	Tolerance	Tolerance Dimension + 0.010 Q255 + 0.000 R0.625	Tolerance Dimension Accept + 0.010 Q755 - + 0.000 R0.625	Tolerance Dimension Accept Reject + 0.010 Q255	Tolerance Dimension Accept Reject Inspection + 0.010 Q255 Vern + 0.000 R0.625 Radius

Measured by: SAD	Audited by:	Prototype Approval:	
Date: 06:05:23	Date: dds/25	Date:	

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			New Issue	KJ/JLM	
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